

Date: Tuesday, 29/07/2008 4:55:41 PM  
 User: Julie Lecocq

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	AFT X-TUBE EXT HEIGHT GEAR
<b>Job Number</b> :	40784		
<b>Estimate Number</b> :	10421		
<b>P.O. Number</b> :		<b>Part Number</b> :	D205596103
<b>This Issue</b> :	29/07/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D205-596-103
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	39550	<b>Drawing Revision</b> :	B
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	JLD 08.7.29	<b>Due Date</b> :	15/08/2008
<b>Comment</b> :	Est Rev:G 05.06.10 Acid etch moved to Step 11KJ/JLM Est RevH 08-01-10 ECN 1075 DD Est Rev F 08.04.28 Added bending & mat'l EC verified by: DD		

Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.8.7



**Comment:** DOCUMENT CONTROL

Photocopy D205-594 bluefile & type labels per PPP D205-596-103 CHG002

2.0	D6008180	Crosstube Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube Extrusion

Batch: B40221

DD 8-8-6

3.0	BENDING CROSS	BENDING MACHINE - CROSSTUBES
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**Comment:** BENDING MACHINE - CROSSTUBES

Bend as per dwg D2890 using CNC bender program

DD 8-8-6

4.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Mark 37.30" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

DD 8-8-6

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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**Comment:** DIMENSIONAL CHECK OF X-TUBES

8/8/6 (+U)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 29/07/2008 4:55:41 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT GEAR

Job Number: 40784

Part Number: D205596103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-103

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

DD 8-8-6

8-8-11

7.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

8 08/08/12 (C)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

TOUCH UP Chemical Conversion Coat as per QSI 005 4.1

AWM 8-8-11

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/08/12 (C)

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

8 08-08-14

11.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

m 08 08 18

(1)

12.0

D3595063530

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

RUBBER CUSHION

batch 39255

m 08 08 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 29/07/2008 4:55:41 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT GEAR

Job Number: 40784

Part Number: D205596103

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch 108720

ml 08 08 18

14.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2940-1

Support 39685

ml 08 08 18

15.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2- Apply magnobond 6398 as per dwg D205-596-103

Magnobond 6398 Batch: 107621

EXP: 08/2009 time: 3:50pm

3- Install supports and clamps per Dwg D205-596-103. Torque clamps to 80-100 in lb. as per dwg

ml 08 08 18 (1)

ml 08 08 19 (1)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/19

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-103

Location: Pen G

AS 08/08/19 (2)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/2008

Job Completion



B40784

MF 08-08-19

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

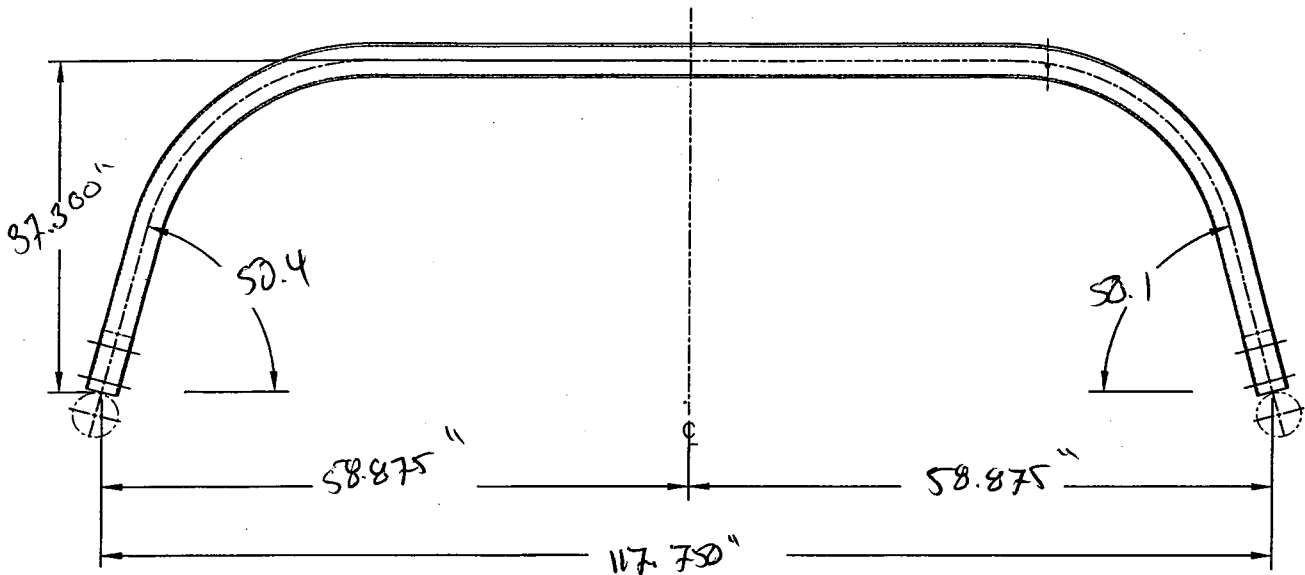
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40784
<b>Description:</b> Crosstube High-High Aft		<b>Part Number:</b> D205-596-103
<b>Inspection Dwg:</b> D205-596-103 <b>Rev:</b> B		<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	37.2	37.4
1/2 Span	58.7	58.9
Angle	49	52
Total Span	117.4	117.8



Comments

QC15 Inspection	8/8/6
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	

**PARTS LIST:**

Qty	Part Number	Description
X	D205-596-103	CROSSTUBE ASSEMBLY, HI-HI AFT
1	D6008-180	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
4	MS21920-28	CLAMP
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURE FROM D6008-180  
FINISHED LENGTH =  $146.98 \pm 0.02$
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH  
VIBRATING STYLUS
- 7) WEIGHT: 55 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO  
BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT  
WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION  
AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1  
SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE  
CROSSTUBE SUPPORT.  
**NOTE:** IT IS ACCEPTABLE TO SUBSTITUTE MS21920-28 CLAMPS WITH LONGER OR SHORTER  
MS21920-XX CLAMPS TO ACCOMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM  
1.5 THREADS IN SAFETY ON THE NUTS.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40784

B	SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-1009 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-530 CUSHION	MB	07.12.03
A	NEW ISSUE	DS	02.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D205-596-103	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE ASSEMBLY, HI-HI AFT	NTS
DATE	07.12.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



